



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-312
Job Sheet 165856



Part No: D350-591-312

Job Qty: 10 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

5001038



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 10/31/17

Created By: Mario Poulin

Type: Stock

Description:

Customer: Airbus Helicopters - Marignane (CEURO24)

Aeroport International De Marseille Cedex Marignane Marseille, , 13725 France ph:+33 4 42 85 85 85 fx:+33 4 42 85 83 00.

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	10 Ea		10/27/17	0.00	0.00	Start up container	
150	QC	10 pcs		10/28/17	0.00	0.00	QC7	
180	Large Fab	10 pcs		10/30/17	0.00	10.00	Large Fab 2	
240	QC	10 pcs		10/31/17	0.00	0.00	QC3	
250	Packaging	10 pcs		10/31/17	0.00	0.00	Packaging1	
260	QC	10 pcs		10/31/17	0.00	0.00	QC4	
265	DC	10 pcs		10/27/17	0.00	0.00	DC	
270	Packaging	10 pcs		10/31/17	0.00	0.00	Packaging3	
280	QC21-FG	10 Ea		10/31/17	0.00	0.00	QC21	

Part Op 180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for Descriptions: welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 6-Grind End Plate flush 7-Install last rivet as per Dwg.

265 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

270 - Identify and pack for shipping as per PPPD350-591-312 Location :FG072

FL084

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D350-591-312 B165856	10	0	0	0

Part Specifications

Specifications could not be found.



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D350-591-312
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Job Qty: 10 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 10/31/17

Created By: Mario Poulin

Type: Stock

Description:

Customer: Airbus Helicopters - Marignane (CEURO24)

Aeroport International De Marseille Cedex Marignane Marseille, , 13725 France ph:+33 4 42 85 85 85 fx:+33 4 42 85 83 00.

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Part/Part Name	Part Note	Serial No	Quantity	Location
D350-591-312 Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible	DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC		0.000	
AN3-35A Bolt			0.000	
AN4-13A Bolt			0.000	
AN5-36A Bolt			0.000	
D2230-3 Mounting Lug	DWG REV G IPP D 00.05.18 Added inspection level 8, and removed P/O for powder coat EC IPP REV :E NEW FOLIO # 10-05-25 JLM VERIFIED BY:EC		0.000	
D2618 Bushing	DWG REV B1 IPP Rev:F Re-format 05-11-22 JLM		0.000	
D2856-400 Abrasion Strip 4" Wide (Per Foot) cut (2) D2856-400-720 as per dwg	DWG REV A IPP D 02.08.28 Re-format; Added clear & 108 foot roll to Step 2 KJ/RF		0.000	
D3065-041 Step Leg Assembly	DWG REV B IPP Rev: C 02.11.01 Incorporated D3066-1 IPP KJ/RF		0.000	
D3066-1 Spacer	DWG REV B IPP: C 02.11.01 Incorporated D3066-1 IPP KJ/RF IPP Rev:B Now M6061-T6 06-06-23 JLM		0.000	
D3067-1 End Plate	DWG REV A IPP: 03.01.21 Remove step 6 (Deburr) KJ IPP Rev:B Now on Water jet 06-06-16 JLM		0.000	
D3067-1 End Plate	DWG REV A IPP: 03.01.21 Remove step 6 (Debu on Water jet 06-06-16 JLM			
D3219-1 Plate	DWG REV B IPP A 04.04.19 New issue KJ/JLM E: EC			
D3235-1 Mounting Lug	DWG REV A IPP A 04.04.19 New issl			
D3272-1 Step	DWG REV B IPP Rev:A New Issue 07-			
D3278-041 Support Assembly	DWG REV C IPP: A 04.04.19 New issue KJ/JLM IF per PAR185 EC Verified by: JL			
MS20600-AD4W4 Rivet				

Status: Stock

Part: D350-591-312 B165856

Created: 9/30/17 12:42 PM DART.MICHAUD-FEBRILLE.VICTORIA



Serial No: S000161

Printed By: Goldston, Justin 10/2/17 10:45 AM

MS21042L3	DWG REV A	0.000
Nut		
MS21042L4		0.000
Nut		
MS21042L5		0.000
Nut		
NAS1149D0363J		0.000
Washer		
NAS1149D0463J		0.000
Washer		
NAS1149D0563J		0.000
Washer		

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	10 Ea	10/27/17	0.00	0.00	Start up container	
100	DC	10 pcs	10/27/17	0.00	0.00	DC	
150	QC	10 pcs	10/28/17	0.00	0.00	QC7	
180	Large Fab	10 pcs	10/30/17	0.00	10.00	Large Fab 2	
240	QC	10 pcs	10/31/17	0.00	0.00	QC3	
250	Packaging	10 pcs	10/31/17	0.00	0.00	Packaging1	
260	QC	10 pcs	10/31/17	0.00	0.00	QC4	
270	Packaging	10 pcs	10/31/17	0.00	0.00	Packaging3	
280	QC21-FG	10 Ea	10/31/17	0.00	0.00	QC21	

Part Op 100 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001
 Descriptions: 180 - 1-Assemble Leg Assembly as per Dwg D3272.
 270 - Identify and pack for shipping as per PPPD350-591-312 Location :FG072

Job BOM

Part / Item	Component Name	Quantity	Operation	Special Comments
D350-591-312 B165856		100 Ea (10 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D350-591-312 B165856	100	10	0	0

Part Specifications

Specifications could not be found.

Work Order Summary

Thursday, September 28, 2017 8:53:46 AM

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Criteria : Work Order ID: 165856 Item ID: D350-591-312 Product Family LARGE FAB
Work Order Start Dates 9/1/2017 to 9/1/2017 11:59:59 PM Work Order Required Dates 9/25/2017 to 9/25/2017 11:59:59 PM
All References
Work Order Status Released

Work Order ID 165856 Required Qty 10.0000 Status Code Released
Item ID D350-591-312 Accepted Qty 0.0000 Scrap Qty 0.0000
Item Name Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible
Current Acct Value \$649.032

Start Date 9/1/2017 Required Date 9/25/2017 Completed Date

Standard ** Actual ** ** Acct. Value ** ** Variance ** ** Variance % **

Direct Costs	Total	Each	Each	Each	Each
Material	\$1,468.070	\$0.000	\$145.938	\$145.938	100.00%
Labor	\$2,040.167	\$0.000	\$136.212	\$136.212	100.00%
Outplant	\$0.011	\$0.000	\$0.002	\$0.002	100.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$4,573.260	\$0.000	\$316.310	\$316.310	100.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$8,081.507	\$0.000	\$598.462	\$598.462	

Item ID/Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
AN3-35A Bolt	20.0000		9/22/2017	20.0000	\$9.400
AN4-13A Bolt	80.0000		9/22/2017	80.0000	\$14.400
AN5-36A Bolt	20.0000		9/22/2017	20.0000	\$17.400
D2230-3 Mounting Lug	40.0000		9/22/2017	40.0000	\$456.156
D2618 Bushing	20.0000		9/22/2017	7.0000	\$52.223
	20.0000		9/25/2017	13.0000	\$193.926
✓ D2856-400-720 Abrasion Strip 4" X 7.20"	20.0000		9/22/2017	20.0000	\$111.946
D3065-041 Step Leg Assembly	10.0000		9/12/2017	10.0000	\$720.818
D3066-1 Spacer	20.0000		9/12/2017	20.0000	\$87.086
D3067-1 End Plate	10.0000		9/12/2017	10.0000	\$21.386
	10.0000		9/5/2017	10.0000	\$21.030
D3219-1 Plate					

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Work Order Summary

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	20.0000	9/28/2017	1.0000	\$3.511
	20.0000	9/6/2017	19.0000	\$58.429
D3235-1 Mounting Lug				
	20.0000	9/22/2017	20.0000	\$231.590
D3272-1 Step				
	10.0000	9/12/2017	10.0000	\$540.446
D3278-041 Support Assembly				
	10.0000	9/22/2017	10.0000	\$932.260
MS20600-AD4W4 Rivet				
	160.0000	9/12/2017	160.0000	\$28.800
MS21042L3 Nut				
	20.0000	9/22/2017	20.0000	\$2.800
MS21042L4 Nut				
	80.0000	9/22/2017	80.0000	\$13.592
MS21042L5 Nut				
	20.0000	9/22/2017	20.0000	\$6.400
NAS1149D0363J Washer				
	40.0000	9/22/2017	40.0000	\$0.800
NAS1149D0463J Washer				
	160.0000	9/22/2017	160.0000	\$4.624
NAS1149D0563J Washer				
	40.0000	9/22/2017	40.0000	\$1.200
			Total Matl Amts:	\$3,530.223

Work Center HandFinish

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
BOUD01												
9/26/2017												
230			0.00	0.00	1.73	1.73	1.00	\$0.000	\$37.816	\$94.394	\$0.000	\$132.210
9/27/2017												
230			0.00	0.00	5.21	5.21	1.00	\$0.000	\$113.563	\$283.464	\$0.000	\$397.026
LECO02												
9/11/2017												
140			0.00	0.00	2.55	1.27	2.00	\$0.000	\$27.753	\$69.275	\$0.000	\$97.028
9/18/2017												
210			0.00	0.00	0.48	0.16	3.00	\$0.000	\$3.502	\$8.741	\$0.000	\$12.243
Total:			0.00	0.00	9.97	8.37	7.00	\$0.000	\$182.634	\$455.873	\$0.000	\$638.507

Work Center Large Fab

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
GAUT02												
	9/12/2017											
180			0.00	0.00	3.39	3.39	1.00	\$0.000	\$72.922	\$148.014	\$0.000	\$220.935
lu01												
	9/5/2017											
110			0.00	0.00	2.27	2.27	1.00	\$0.000	\$48.822	\$99.098	\$0.000	\$147.920
	9/6/2017											
110			0.00	0.00	5.09	5.09	1.00	\$0.000	\$109.512	\$222.285	\$0.000	\$331.797
110			0.00	0.00	3.73	3.73	1.00	\$0.000	\$80.189	\$162.764	\$0.000	\$242.953
	9/7/2017											
110			0.00	0.00	2.00	2.00	1.00	\$0.000	\$43.071	\$87.424	\$0.000	\$130.495
110			0.00	0.00	1.29	1.29	1.00	\$0.000	\$27.675	\$56.173	\$0.000	\$83.848
110			0.00	0.00	23.41	23.41	1.00	\$0.000	\$503.238	\$1,021.455	\$0.000	\$1,524.693
	9/12/2017											
180			0.00	0.00	0.83	0.83	1.00	\$0.000	\$17.882	\$36.295	\$0.000	\$54.177
	9/13/2017											
180			0.00	0.00	3.89	3.89	1.00	\$0.000	\$83.534	\$169.555	\$0.000	\$253.089
180			0.00	0.00	4.83	4.83	1.00	\$0.000	\$103.791	\$210.672	\$0.000	\$314.463
	9/14/2017											
180			0.00	0.00	4.40	4.40	1.00	\$0.000	\$94.701	\$192.221	\$0.000	\$286.922
Total:			0.00	0.00	55.13	55.13	11.00	\$0.000	\$1,185.336	\$2,405.956	\$0.000	\$3,591.292

Work Center Powdercoat

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
ROQU01												
	9/19/2017											
220			0.00	0.00	1.32	1.32	1.00	\$0.000	\$28.802	\$71.894	\$0.000	\$100.696
220			0.00	0.00	2.90	2.90	1.00	\$0.000	\$63.153	\$157.637	\$0.000	\$220.790
Total:			0.00	0.00	4.22	4.22	2.00	\$0.000	\$91.955	\$229.530	\$0.000	\$321.485

Work Order ID 165856

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Item ID: D350-591-312
 Revision ID:
 Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible
 Start Date: 9/1/2017 Start Qty: 10.00
 Required Date: 9/25/2017 Req'd Qty: 10.00
 Reference:

Accept

N900040100

Setup Start *NS1*
 Stop *NS2*

Cust Item ID:
 Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3272	Rev B

100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and type labels as per PPP D350-591-312 CHG001								

110	Weld per dwg A/R Aluminum rod Batch: _____	0.00							
110	Large Fab								
Large Fab	Memo	4.00							
Large Fab	1-Bevel end for welding FWD ONLY								
	2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Dwg D3272								
	A/R Aluminum Rod M136158								
	3-Grind End Plate flush								

x10 SL 2017.9.7

Work Order ID 165856***165856***

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Item ID: D350-591-312 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible
Start Date: 9/1/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 9/25/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				(15)	15.09.11		DAS 9 9-89
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.20				(15)	17.09.11		DAS 9 9-89
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 4.10				(RH)	(10)	2017/09/11 JSL BIEB	

Work Order ID 165856

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Page 3

Item ID: D350-591-312 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible
Start Date: 9/1/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 9/25/2017 Req'd Qty: 10.00 ***10*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Memo

0.10

Quality Control

180

Weld per dwg A/R Aluminum rod Batch: _____ 0.00

Large Fab

180

Large Fab

Memo

4.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/RAluminum Rod M136153

6-Grind End Plate flush

7-Install last rivet as per Dwg.

x10S.L 2017-9-1410x 20 2017-09-12

Work Order ID 165856

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Item ID: D350-591-312 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible
Start Date: 9/1/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 9/25/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							<u>(10) 17-09-14 PD</u>
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.20							<u>(10) 17-09-14 PD</u>
210 *210* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 1.00							<u>(RH) (10) 2017-09-18</u> JSL BER

Work Order ID 165856***165856***

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Thursday, August 31, 2017 1:28:30 PM

Item ID: D350-591-312 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible
Start Date: 9/1/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 9/25/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 *220* Powdercoat Powder Coating	White Gloss (Ref: 4.3.5.1) per OSI005 4.3-Alum <i>M 18504</i> Memo START TIME: <i>12:00</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>12:30</i>	0.00 2.10				<i>10</i>	<i>0</i>	<i>17-09-19</i>	<i>JAS 34 9-89</i>
230 *230* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <i>1138373</i> Memo	0.00 2.20							<i>X10 RH</i>
240 *240* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.10				<i>10</i>			<i>Ph - 8</i> <i>JAS 38 9-89</i> <i>OCT 19 2017</i>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☒</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☒	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																																																	
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																																	
Thermoforming ☐	Finishing ☒	Rec/Store/Packaging ☐	Other ☐																																																																	
Large Fab ☐	Composite ☐	Supplier ☐																																																																		
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval																																																																
Description Work Order Deviation		Disposition		5/17/09/27 Completed By 17-10-17 Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval 5/7/09/27																																																																
Found AFTER Powder coat that YELLOW marks Found in FWD out Bands side of the STEP. RC.		TAPE FWD BRACKET. • Scuff Entire Step Down to approx w/320 grit Paper. • Smooth out all surfaces. • Re Powder coat M138014 START 1:00. O.V.T: 320° FINISH 4:30.																																																																		
Root Cause <table style="width:100%; border: none;"> <tr> <td style="border: none;">Environment ☐</td> <td style="border: none;">No Re-verification ☐</td> </tr> <tr> <td style="border: none;">Design ☐</td> <td style="border: none;">Operator ☐</td> </tr> <tr> <td style="border: none;">Doc/Data ☐</td> <td style="border: none;">Offset/Setup ☐</td> </tr> <tr> <td style="border: none;">Equip/Tooling ☐</td> <td style="border: none;">Supplier ☐</td> </tr> <tr> <td style="border: none;">Handling/Pre ☐</td> <td style="border: none;">Training ☐</td> </tr> <tr> <td style="border: none;">Material ☐</td> <td style="border: none;">Use for Testing ☐</td> </tr> <tr> <td style="border: none;">Internal Transport ☐</td> <td style="border: none;">Poor Information ☐</td> </tr> <tr> <td style="border: none;">Tribal Knowledge ☐</td> <td style="border: none;">Rushing ☐</td> </tr> <tr> <td style="border: none;">LOA ☐</td> <td style="border: none;">Product Improvement ☐</td> </tr> <tr> <td style="border: none;">Substation ☐</td> <td style="border: none;">Process Improvement ☐</td> </tr> <tr> <td style="border: none;">Past Expiry Date ☐</td> <td style="border: none;">Manufacturing Process ☐</td> </tr> <tr> <td style="border: none;">Misidentified ☐</td> <td style="border: none;">Past Due ☐</td> </tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	FAULT CATEGORY <table style="width:100%; border: none;"> <tr> <td style="border: none;">Pressure/Forced ☐</td> <td style="border: none;">Temperature/Cure ☐</td> <td style="border: none;">Power Loss/Surge ☐</td> <td style="border: none;">Positioned Wrong ☐</td> </tr> <tr> <td style="border: none;">Bending ☐</td> <td style="border: none;">Set-up ☐</td> <td style="border: none;">Folio/Program ☐</td> <td style="border: none;">Outside Dimensions ☐</td> </tr> <tr> <td style="border: none;">Centre Not Concentric ☐</td> <td style="border: none;">BOM/Route ☐</td> <td style="border: none;">Grain ☐</td> <td style="border: none;">Over/Under tolerance ☐</td> </tr> <tr> <td style="border: none;">Cracks ☐</td> <td style="border: none;">Broken/Damage/Defect ☐</td> <td style="border: none;">Weld ☐</td> <td style="border: none;">Part Incorrect ☐</td> </tr> <tr> <td style="border: none;">Crimp/Kink/Ripple/Wave ☐</td> <td style="border: none;">Inspection Incomplete/Unqualified ☐</td> <td style="border: none;">Wrong Stock Pulled ☐</td> <td style="border: none;">Part Lost/Missing ☐</td> </tr> <tr> <td style="border: none;">Cuffs ☐</td> <td style="border: none;">Contamination ☐</td> <td style="border: none;">Out of Sequence ☐</td> <td style="border: none;">Part Moved ☐</td> </tr> <tr> <td style="border: none;">Crushing ☐</td> <td style="border: none;">Countersink ☐</td> <td style="border: none;">Off-set ☐</td> <td style="border: none;">Drawing ☐</td> </tr> <tr> <td style="border: none;">Heat Treat ☐</td> <td style="border: none;">Cut Too Short ☐</td> <td style="border: none;">Mislabeled ☐</td> <td style="border: none;">Finish ☐</td> </tr> <tr> <td style="border: none;">Wave/Twist in Tube ☐</td> <td style="border: none;">Instructions Incomplete/Unclear ☐</td> <td style="border: none;">Fit/Function ☐</td> <td style="border: none;">Misread ☐</td> </tr> <tr> <td style="border: none;">Marks/Chatter ☐</td> <td style="border: none;">Drill Holes ☐</td> <td style="border: none;">Misaligned/off center ☐</td> <td style="border: none;">Turning Sequence ☐</td> </tr> </table>			Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
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OTHER : _____																																																																				

165856

Page 6

N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

250	Pick Kit	0.00
-----	----------	------

250	Pick Kit	0.00
-----	----------	------

Packaging	Memo	0.10	10	SEP 27 2017	DA
-----------	------	------	----	-------------	----

Packaging

260	QC4- 100% Inspect kits for completeness	0.00	
-----	---	------	--

	Memo	0.30					
--	-------------	------	--	--	--	--	--

Quality Control

270	Identify as per dwg & Stock Location:	0.00
-----	---------------------------------------	------

Packaging	Memo	SOLD	0.00		DAS			
-----------	------	------	------	--	-----	--	--	--

Packaging	Identify and pack for shipping as per PPPD350-591-312
-----------	---

Identify and pack for shipping as per PPPD350-591-312
Location :FG072

OCT 23 2017

165856

Thursday, August 31, 2017 1:28:30 PM

N900040100

Stop *NS2*

Reference:

Stop *NR2*

ᲗᲘᲚ

1.00

Quality Control

Picklist Print

Page 1

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Work Order ID: 165856

165856

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 9/1/2017

Required Date: 9/25/2017

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D

fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-35A		Purchased	No			250	Each	96.0000	2	20			
AN3-35A									**			SEP 22 2017	DAS 6 27 9-89
Bolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				10					
				122800				10					
				ST348				86					
				M138170				86					
AN4-13A		Purchased	No			250	Each	344.0000	8	80			
AN4-13A									**			SEP 22 2017	DAS 6 27 9-89
Bolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				20					
				122808				20					
				GA				9					
				m135470				9					
				ST344				315					
				m138170				115					
				m138326				200					

Picklist Print

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Work Order ID: 165856

165856

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 9/1/2017

Required Date: 9/25/2017

Start Qty: 10.00

Required Qty: 10.00

AN5-36A

Purchased

No

250

Each

78.0000

2

20

AN5-36A

Bolt

DAS
28
9-89

Location

Loc Qty

Loc Code

ST336

78

m137963

50

m138209

28

D2230-3

Manufactured

No

250

Each

272.0000

4

40

D2230-3

Mounting Lug

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

4

109344

4

ST521

268

162754

28

163291

80

164011

160

D2618

Manufactured

No

250

Each

41.0000

2

20

D2618

Bushing

DAS
28
9-89

Location

Loc Qty

Loc Code

ST008A

41

163460

41

164495

BK5366

13 X

1

SEP 22 2017

DAS
6
9-89

DAS
27
9-89

DAS
3
9-89

SEP 22 2017

DAS
27
9-89

SEP 22 2017

DAS
6
9-89

DAS
27
9-89

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Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 165856

165856

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 9/1/2017

Required Date: 9/25/2017

Start Qty: 10.00

Required Qty: 10.00

D2856-400

Manufactured No

250 f

94.5810

1.2

12

***D2856-400*-7.2**

Abrasion Strip 4" Wide (Per Foot)

DAS
28
9-89

Location

Loc Qty

Loc Code

ST418

94.58099526

146265

27.4088853

152590

29.89211

160547

37.28

5/16/2018

165231

SEP 22 2017

DAS
2
6 DAS
27
9-89

cut (2) D2856-400-720 as per dwg

D3065-041

Manufactured No

180

Each

28.0000

1

10

D3065-041

Step Leg Assembly

**

SG 2017-09-12

Location

Loc Qty

Loc Code

WA002

28

162415

2

164384

1

165204

25

180

Each

54.0000

2

20

D3066-1

Manufactured No

D3066-1

Spacer

**

SG 2017-09-12

Location

Loc Qty

Loc Code

WA003

54

159117

4

162500

50

110

Each

20.0000

1

10

D3067-1

Manufactured No

D3067-1

End Plate

B165725 ** → S.L 2017-9-12

Location

Loc Qty

Loc Code

WA003

20

163742

20

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Shop Packet Print

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Picklist Print

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Work Order ID: 165856

165856

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 9/1/2017

Required Date: 9/25/2017

Start Qty: 10.00

Required Qty: 10.00

D3067-1

Manufactured No

180 Each

20.0000 1 10

D3067-1 ✓

End Plate

**

x10 S.L 2017-9-7

Location

Loc Qty

Loc Code

WA003

20

163742

20

D3219-1

Manufactured No

110 Each

21.0000 2 20

D3219-1 ✓

Plate

**

Location

Loc Qty

Loc Code

WA003

21

162382

16

162848

5

D3235-1

Manufactured No

250 Each

83.0000 2 20

D3235-1

Mounting Lug

**

x9
x16
x7
not pulled * } S.L 2017-9-7

DAS
28
9-89

Location

Loc Qty

Loc Code

ST522

83

162757

83

D3272-1

Manufactured No

110 Each

21.0000 1 10

D3272-1

Step

**

SEP 22 2017
20
DAS 6 9-89
2017-09-12

Location

Loc Qty

Loc Code

WA003

21

164356

10

164968

11

\$165581 → 10

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Shop Packet Print

Page 4

Picklist Print

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Page 5

Work Order ID: 165856

165856

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 9/1/2017

Required Date: 9/25/2017

Start Qty: 10.00

Required Qty: 10.00

D3278-041

Manufactured No

250

Each

38.0000

1

10

D3278-041

Support Assembly

**

DAS 6
9-89 SFP 7.2.2017
DAS 27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST522

38

~~160701~~

2

~~161350~~

16

~~164347~~

20

165569 Y10

MS20600-AD4W4

Purchased

No

180

Each

517.0000

16

160

MS20600-AD4W4

Rivet

**

2017-09-12

Location

Loc Qty

Loc Code

ST308

29

M138209

29

WA003

488

M135442

204

M136986

108

M137412

63

M137820

21

M138209

92

B138209 → 11
B138441 → 149

Picklist Print

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Work Order ID: 165856

165856

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 9/1/2017

Required Date: 9/25/2017

Start Qty: 10.00

Required Qty: 10.00

MS21042L3

Purchased

No

250

Each

1,327.000

2

20

MS21042L3

Nut

**

SEP 22 2017

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

72

m135945

72

GA

336

m134360

102

M136665

234

ST303

919

M126333

16

m138084

14

m138230

500

m138326

389

20

MS21042L4

Purchased

No

250

Each

2,581.000

8

80

MS21042L4

Nut

**

SEP 22 2017

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

10

m133363

10

OVER007

1000

m138170

500

m138230

500

ST303

1571

127376

24

m138084

547

m138326

1000

20

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Shop Packet Print

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Picklist Print

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Page 7

Work Order ID: 165856

165856

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 9/1/2017

Required Date: 9/25/2017

Start Qty: 10.00

Required Qty: 10.00

MS21042L5

Purchased

No

250

Each

519.0000

2

20

MS21042L5

Nut

**

SEP 22 2017

DAS

27

9-89

DAS

6

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

10

m127813

10

ST303

509

125535

4

m137587

5

m137963

200

m138209

200

m138336

100

20

NAS1149D0363J

Purchased

No

250

Each

1,407.000

4

40

NAS1149D0363J

Washer

**

SEP 22 2017

DAS

27

9-89

DAS

27

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

408

m137963

408

ST263

999

126319

16

m138336

983

40

Picklist Print

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Work Order ID: 165856

165856

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 9/1/2017

Required Date: 9/25/2017

Start Qty: 10.00

Required Qty: 10.00

NAS1149D0463J

Purchased

No

250

Each

2,738.000

16

160

NAS1149D0463.J

Washer

**

SEP 22 2017

DAS
27
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA	547	
M135056	40	
M137699	507	
Return2017	16	
M136665	16	
ST263	2175	
127693	48	
M137988	600	
M138084	71	
M138230	1456	

DAS
28
9-89

NAS1149D0563J

Purchased

No

250

Each

1,463.000

4

40

NAS1149D0563.J

Washer

**

SEP 22 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

GA	36	
m135774	36	
ST263	1427	
m126319	16	
m137820	11	
m138040	700	
m138209	700	

DAS
28
9-89

DAS
6
9-89



DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG SCALE NTS	
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *H*



QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

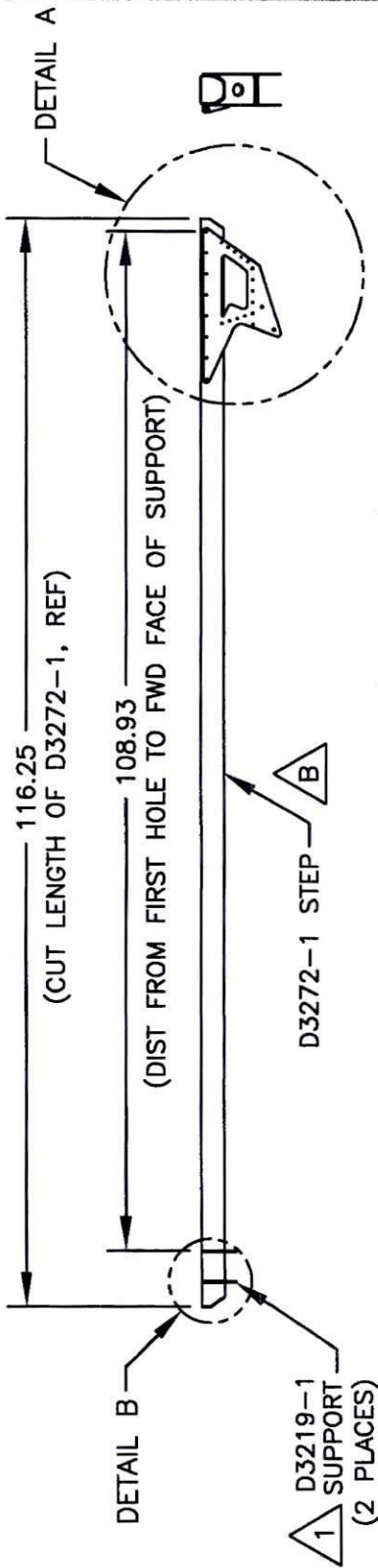
celo 165856

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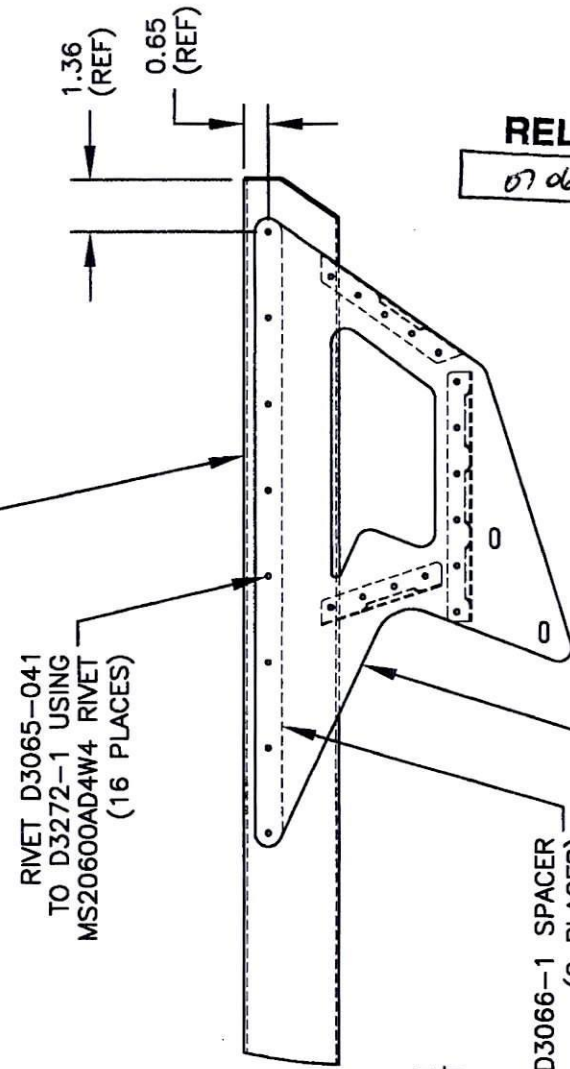
DESIGN <i>GP</i>	DRAWN BY <i>JB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 2 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20



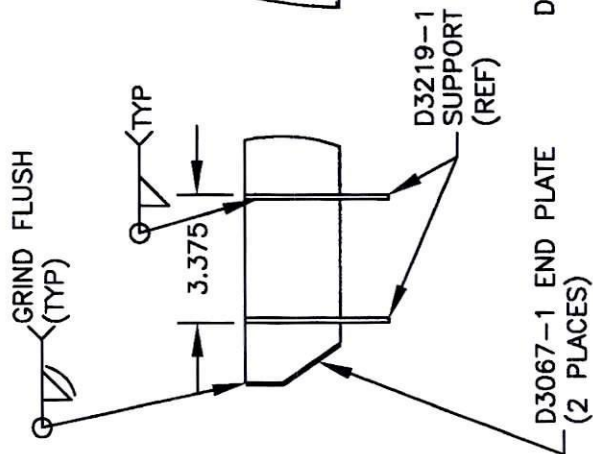
D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

APPLY BLACK ANTI-SKID
ON TOP SURFACE TO
BOTTOM OF TOP RADIUS

RIVET D3065-041
TO D3272-1 USING
MS20600AD4W4 RIVET
(16 PLACES)



DETAIL A
(SCALE 1:5)



DETAIL B
(SCALE 1:5)

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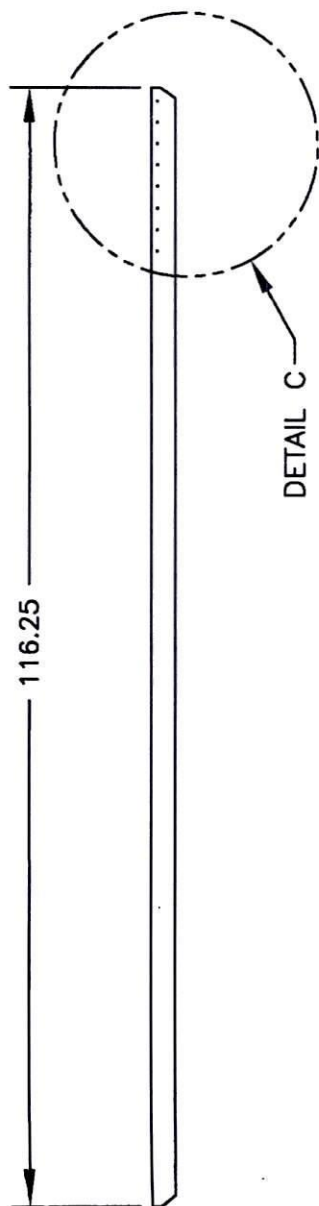
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DESIGN <i>qp</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

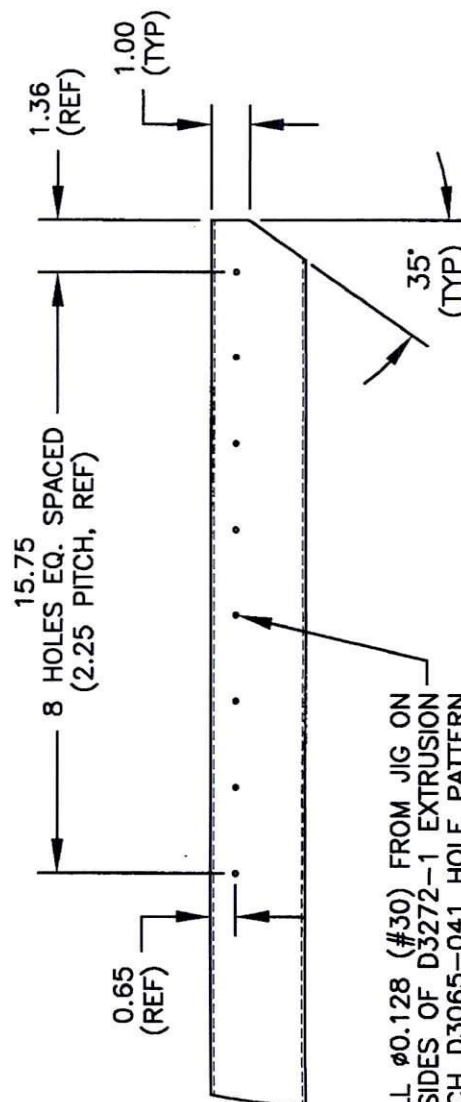
07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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S001038

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA

TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



**Heli - Access - Step RH - High Gear, Long Step, Aerazur
Float Compatible**

PART NO: D350 - 591 - 312

Revision:

Operation: QC

Quantity: 10

Change No:

Mfg Date: 10/19/17

Job No: 165856

B#165856 X/D



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Pick list

Shipper Info

Shipper No: 00167



Order No: 9

Customer: Airbus Helicopters - Marignane

Ship To: Aeroport Intl De Marseille Cedex, Livraison R7 ,
Marseille
13725 Marignane
France

Ship Via: SDV

Scheduled Ship Date: 10/23/17

Shipping Instructions:

CAITLIN - USE SDV FOR SHIPPING, All products need to be boxed and shipped separately.

Part	Customer Part	Part Name	Release Qty	Loaded Qty	Loaded Count	Location	Master Unit	Containers	Container Original Serial No	Qty	Gross Weight	Oldest
D350-591-311	D350-591-311	Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible	20	0	0	FG084		1		8	0	10/17/17
								S000725	S000725	8	0	10/17/17 8:51 AM
D350-591-312	D350-591-312	Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible	20	0	0	FG084		1		1	0	10/5/17
								F165142	165142	1	0	10/5/17 10:14 AM

Plex 10/23/17 1:51 PM Dart.Larocque.Sylvie Page 1

D350-591-312 - S001038 (x10)

inv. #107/70698328